

Work Order ID 64610



Page 1

Thursday, December 09, 2010 10:16:53 AM

Item ID: D206-642-151 *Right Hand*

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 12/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *10/29* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-151 CHG001

N/A

Right Hand

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐

M116577 BE 11/05/04

4-Grind weld flush to cap on top surface only.

BE 11/05/04

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

> DP

11-5-3

> DP 11-5-4

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

11-5-4

11-5-5

120



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

11/05/06

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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

~~1- Open crosshole holes to Ø0.3125"~~~~2- Open Aft cap hole #6.~~~~****no wearplate holes for this skidtube****~~

3-Debur tube and blow out chips from inside the tube

140

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

B 11/05/10

150

0.00



QC3- Inspect Part Finish

QC

Memo

0.00

Quality Control

B 11-5-10

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 Skidtubes | Skidtubes | 0.00 | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-Open holes to finished size as per Dwg D3804, (without cutting fluid) | | | | | | | | |
| | 2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid) | | | | | | | | |
| | 3-Deburr and blow out all chips from inside the tube | | | | | | | | |
| 170 QC | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | |

11.05.10

11-5-10

| W/O: | | WORK ORDER CHANGES | | | | | |
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 | Skidtubes | 0.00 | | | | | | | |
| Skidtubes | Memo 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required <u>D2654-1</u> 2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting Start Date: <u>11-5-17</u> Time: <u>1030</u> Finish Date: <u>11-6-18</u> Time: <u>9:30am</u> Pick: Qty <input type="checkbox"/> Part Number <input type="checkbox"/> Description <input type="checkbox"/> Batch <input type="checkbox"/> A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> <u>M110948</u> <input type="checkbox"/> Sikaflex expire date: <u>12-1-15</u> | 0.00 | | | | | | | |
| 190 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | | | | |

11.05.10

Pro →

DP

11-5-17

S. Kestice

②

| WIO: 64610 | | WORK ORDER CHANGES | | | | | |
|------------|---------|--|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 11/05/06 | # 180-2 | Perm. change Call for the wrong web. should be D2654-1 not -3. Fix and review all w/o's. Print copy and detail as Ref. | EE | 11/06/02 | | | 8 11/05/06 |
| | | | | | | | |

Part No: D206-642-151 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

BE 11/05/19

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐

M111385

BE 11/05/19

3-Grind welds flush as per Dwg D3804.

DD 11-5-19

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐

NONE

BE 11/05/25

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 11/05/25

| W/O: | | WORK ORDER CHANGES | | | | | |
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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

210

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804

1

11/05/26.

220

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

8 11/05/27

Pto →

230

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 11/05/27

2

| WIO: 64610 | | WORK ORDER CHANGES | | | | | | |
|------------|------|--|----|----------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 11/5/27 | 220 | Perm. chan change to QC 10 inspection | E | 11.06.02 | | | 11/15/27 | |
| | | | | | | | | |

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240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

IX ~~Ø~~ M/L 11/06/30

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:50
320 OF
12:20

0.00

IX ~~Ø~~ M/L 11/05/30

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 ~~Ø~~ XL 11/06/10

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| 270 | HandFinishing | 0.00 | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. | | | | | 1 | 0 | 11/06/01 | |
| 280 | HandFinishing | 0.00 | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> M1176945 <input type="checkbox"/> Sikaflex expire date: <input type="checkbox"/> 12/01 | | | | | 1 | 0 | 11/06/01 | |
| | 2- Install wearplate as per dwg | | | | | | | | |
| | 2-Wing Walk as per Dwg D3804 and QSI 005 4.4 <input type="checkbox"/> Batch: M117315 | | | | | | | | |

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Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

QC3- Inspect Part Finish

0.00



0.00 8466101

QC

Memo

Quality Control

300

QC5- Inspect part completeness to step on W/O

0.00



0.00 8466101

QC

Memo

Quality Control



310

Packaging

0.00



0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev:

PPP

64575 6448/2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 64610

Page 12

Thursday, December 09, 2010 10:16:53 AM

Item ID: D206-642-151

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 12/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

320

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/12
mf
11-06-02

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:16:59 AM

Page 1

Work Order ID: 64610.

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube



Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV:N DD VER:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2620
Skidtube, 206 Skidtube

Location

LG

62684

Loc Qty

9

9

Each

Loc Code

1

23.0000

1

1

11-5-3

D3286-1
Doubler

Location

ST050

52844

Loc Qty

23

23

Each

Loc Code

2

57.0000

1

1

11-5-4

BR 11/05/04

D2647
Cap

Location

FP

55352

Loc Qty

57

57

Each

Loc Code

1

425.0000

52

52

11-05-10

CR3212-4-04
Cherry Rivet

Location

ST311

112314

113749

115698

116471 (52)

Loc Qty

425

25

200

200

Loc Code

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:16:59 AM

Page 2

Work Order ID: 64610

Parent Item: D206-642-151

Parent Item Name: Replacement Skid:be

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-1 Manufactured No

B64781

Each

0.0000

1

1



Web

D2649 Manufactured No

Each

53.0000

19

19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG 53

58545 2

60652 4

61496 2

62889 13

63359 32

D3286-3 Manufactured No

Each

7.0000

2

2



Spacer

Location

Loc Qty

Loc Code

LG 7

46643 7

CCR264SS3-3 Purchased No

Each

330.0000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311 330

112314 4

113539 44

113973 282

117086

2

Bulost/26

Thursday, December 09, 2010 10:16:59 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:16:59 AM

Work Order ID: 64610

Parent Item: D206-642-151

Parent Item Name: Replacement Skidube

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

Each

1,873.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

1873

110153

35

111359

5

112314

2

114436

448

114450

37

114859

1346

D2680-041

Manufactured

No

Each

20.0000

1

1



Nut Plate

Location

Loc Qty

Loc Code

ST021

20

55366

20

Each

0.0000

1

D3805-041

Manufactured

No



Wearplate Assembly Fwd, Low Gear

D3805-045

Manufactured

No

Each

0.0000

1

1



Wearplate Assembly Aft, Low Gear

AN3-37A

Purchased

No

Each

654.0000

7

7



Bolt

Location

Loc Qty

Loc Code

ST353

654

105425

154

111668

500

BB 11/05/26

BB 11/05/26

1361565 (x1) 11/1/06/01

1364566 (x1) 11/1/06/01

1364566 (x1) 11/1/06/01

1364566 (x1) 11/1/06/01

1364566 (x1) 11/1/06/01

1364566 (x1) 11/1/06/01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:16:59 AM

Work Order ID: 64610

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/9/2010

Required Date: 1/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10 NAS1149D0363J Purchased No

Each 8.0000 7 7



Washer



Handwritten: 11/06/10

Location

Loc Qty

Loc Code

ST 107715
ST335 105792

6
6
2
2

Handwritten: 1116583

Handwritten: x7

MS21042L3 Purchased No

Each 1,213.000 7 7



Nut



Handwritten: 11/06/10

Location

Loc Qty

Loc Code

ST300 114784
115835

1213
217
996

Handwritten: 1116540

Handwritten: x7

D3873-1 Manufactured No

Each 81.0000 14 14



Bushing



Handwritten: 11/06/10

Location

Loc Qty

Loc Code

ST092 62197
63314
ST093 57615

70
40
30
11
11

Handwritten: 1364760

Handwritten: x14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:16:59 AM

Work Order ID: 64610

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD416 NAS1149D0463J Purchased No

Each 30.0000 1 1



Washer



all 4/06/01

Location

Loc Qty

Loc Code

ST300

24

1117291

XL

113288

24

ST356

6

115622

6

D2651-1 Manufactured No

Each 539.0000 6 6



Plug



all 4/06/01

Location

Loc Qty

Loc Code

FP

217

B67760

XL

51530

152

62638

65

fpa

322

53349

205

57869

117

D2651-3 Manufactured No

Each 432.0000 6 6



O-Ring



all 4/06/01

Location

Loc Qty

Loc Code

FP

432

46114

12

61962

420

XL

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Thursday, December 09, 2010 10:16:59 AM

Work Order ID: 64610

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/9/2010

Required Date: 1/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

Each

95.0000

1

1



Screw



Handwritten: 11106101

Location

Loc Qty

Loc Code

ST292

95

109061

5

~~115460~~

90

Each

76.0000

1

1

D2646

Manufactured

No



Aft Cap



Handwritten: 11106101

Location

Loc Qty

Loc Code

FP-4

17

57332

17

FP6

5

52663

3

63633

2

Return 2010

54

~~62678~~

54

Each

1,364.000

2

2

MS27039-1-08

Purchased

No



Screw



Handwritten: 11106101

Location

Loc Qty

Loc Code

ST291

1364

107378

1

108077

37

~~110835~~

455

115108

871

Handwritten: x2

Picklist Print

Page 7

Thursday, December 09, 2010 10:16:59 AM

Work Order ID: 64610



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Star Date: 12/9/2010

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L ~~NAS1149D0332J~~ Purchased

No

Each

38.0000

2

2



96 1106101

Washer

Location

Loc Qty

Loc Code

ST182

38

104885

38

11117291

x2

Thursday, December 09, 2010 10:16:59 AM

Shop Packet Print

Page 7

| ITEM | Qty -041- | Qty -043 | Part Number | Description |
|------|--------------|-------------|--------------|---------------------------------|
| 1 | X | | D3804-041 | SKIDTUBE ASSEMBLY, 206 A/B LOW |
| 2 | | X | D3804-043 | SKIDTUBE ASSEMBLY, 206 A/B HIGH |
| 5 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 6 | 1 | 1 | D2646 | AFT CAP |
| 7 | 1 | 1 | D2647 | CAP |
| 8 | 19 | 20 | D2649 | CROSS BOLT SPACER |
| 9 | 6 | 8 | D2651-1 | PLUG |
| 10 | 6 | 8 | D2651-3 | O-RING |
| 11 | | 1 | D2654-3 | WEB |
| 12 | 1 | | D2654-1 | WEB |
| 13 | 1 | 1 | D2680-041 | NUT PLATE |
| 14 | 2 | 2 | D3286-1 | DOUBLER |
| 15 | 2 | 2 | D3286-3 | STUD |
| 21 | 2 | 2 | AN960JD10L | WASHER |
| 22 | 1 | 1 | AN960JD416 | WASHER |
| 23 | 2 | 2 | CCR264SS3-3 | RIVET |
| 24 | 2 | 2 | CR3212-4-03 | RIVET |
| 25 | 52 | 52 | CR3212-4-04 | RIVET |
| 26 | 2 | 2 | MS27039-1-08 | SCREW |
| 27 | 1 | 1 | MS27039-4-06 | SCREW |

NOTES

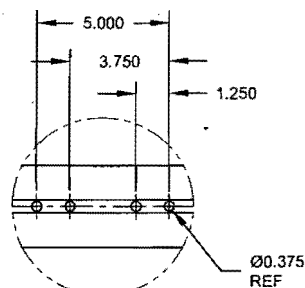
- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 444610
BP 10-12-14

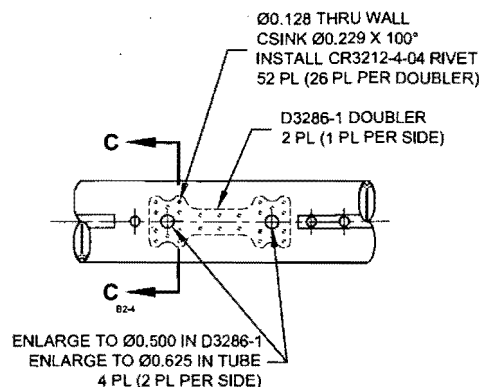
RELEASED
UP 09.03.03
PC ECN 09-536

| | | | |
|------------|-------------|--|--------------|
| A | NEW ISSUE | MB | 08.07.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 97 | DART AEROSPACE USA, INC | |
| DRAWN | | PORT HADLOCK, WA | |
| CHECKED | 97 | DRAWING NO. | REV. A |
| MFG. APPR. | 97 | D3804 | SHEET 1 OF 5 |
| APPROVED | 97 | TITLE | SCALE |
| DE APPR. | 97 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
| DATE | 08.07.07 | COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

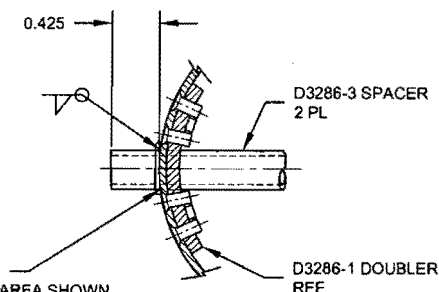
RELEASED
09.03.07



DETAIL A D6-2
SCALE NONE C2-2
D6-3
C2-3

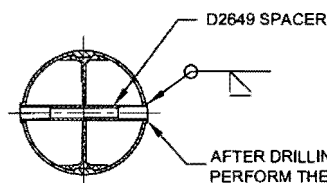


DETAIL B C3-2
SCALE NONE C3-3



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



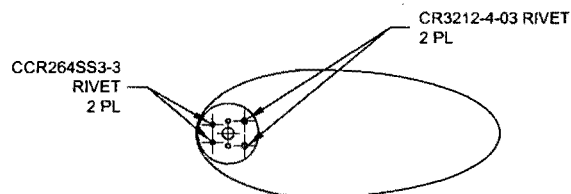
SECTION D-D A4-2
FOR Ø0.375 HOLES ONLY A4-3
SCALE NONE

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORER TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

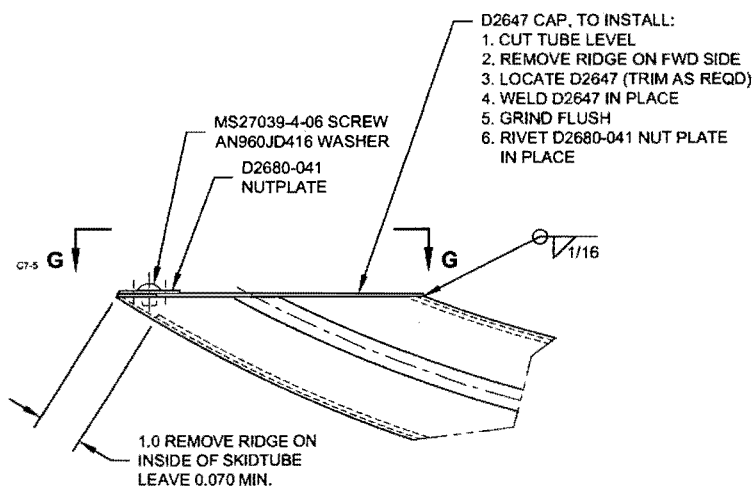
| | | | |
|------------|----------|--|--------------|
| DESIGN | 91 | DART AEROSPACE USA, INC | |
| DRAWN | 1 | PORT HADLOCK, WA | |
| CHECKED | 91 | DRAWING NO. | REV. A |
| MFG. APPR. | 91 | D3804 | SHEET 4 OF 5 |
| APPROVED | 91 | TITLE | SCALE |
| DE APPR. | 91 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
| DATE | 08.07.07 | COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

RELEASED
07 07 07

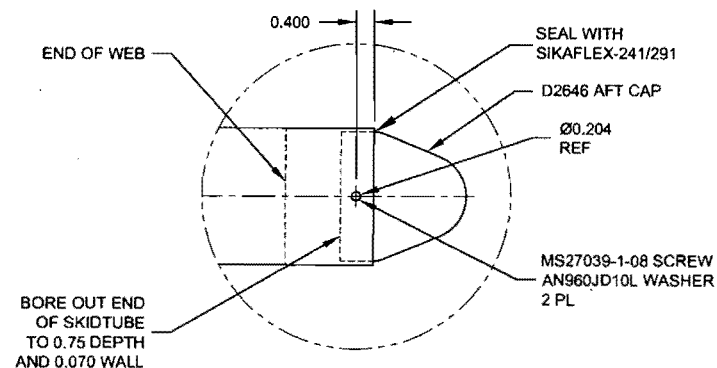
u064610



VIEW G-G
SCALE NONE
A7-5



DETAIL E
SCALE NONE
B7-2
B7-3



DETAIL F
SCALE NONE
B2-2
B2-3

| | | | |
|------------|----------|--|--------------|
| DESIGN | 07 | DART AEROSPACE USA, INC | |
| DRAWN | 07 | PORT HADLOCK, WA | |
| CHECKED | 07 | DRAWING NO. | REV. A |
| MFG. APPR. | 07 | D3804 | SHEET 5 OF 5 |
| APPROVED | 07 | TITLE | SCALE |
| DE APPR. | 07 | SKIDTUBE ASSEMBLY, 206A/B | NTS |
| DATE | 08.07.07 | <small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

NO. 252

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 66358
Part number: D206 642 541
Description: 206
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat Burns Date of Test Coupon 11-05-09
Welder Barclay Elliott Date of Test Coupon 11-05-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld